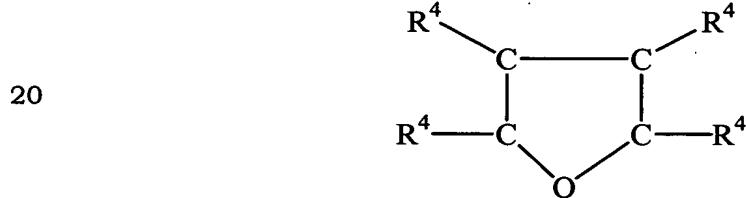


CLAIMS

What is claimed is:

- 5           1. A film prepared from a urea/urethane polymer comprising  
              (a) repeating units derived from a hydroxy-terminated copolymer prepared  
              from tetrahydrofuran and one or both of an alkylene oxide and a cyclic  
              acetal, and (b) repeating units derived from a polyisocyanate;  
              wherein the urea/urethane polymer contains less than about  
 10      2 mole percent of urea units described by the formula  $-R - N(R^2) - C(O) -$   
               $N(R^2) - R^1 -$  ;  
              wherein R is an aromatic hydrocarbon radical, R<sup>1</sup> is an  
              aliphatic hydrocarbon radical, and R<sup>2</sup> is H or an amide group that is  
              described by the formula  $-C(O) - N(R^2) - R -$ ; and  
 15       wherein the tetrahydrofuran is described by the formula



25       in which any one of the R<sup>4</sup>s may be a C<sub>1</sub> to C<sub>4</sub> alkyl radical with the  
              remaining R<sup>4</sup>s being hydrogen.

- 30           2. A film according to Claim 1 wherein the polyisocyanate is  
              selected from the group consisting of toluene diisocyanate, methylene  
              diphenyldiisocyanate and polymethylene polyphenylisocyanate.
- 35           3. A film according to Claim 1 wherein the alkylene oxide is  
              selected from the group consisting of 1,2-propylene oxide and ethylene  
              oxide.
- 35           4. A film according to Claim 1 wherein the alkylene oxide is  
              ethylene oxide.

5. A film according to Claim 1 wherein each R<sup>4</sup> in the tetrahydrofuran is hydrogen.
6. A film according to Claim 1 wherein each R<sup>4</sup> in the  
5 tetrahydrofuran is hydrogen, the hydroxy-terminated copolymer is prepared from an alkylene oxide, and the alkylene oxide is ethylene oxide.
7. A film according to Claim 1 wherein the urea/urethane polymer contains less than about 1 mole percent of the described urea  
10 units.
8. A film according to Claim 1 wherein the urethane polymer further comprises repeating units derived from an ionic compound or a potentially ionic compound.  
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9. A film according to Claim 1 that is prepared from an aqueous dispersion of the urea/urethane polymer of Claim 1 and a surfactant.
10. A film prepared from an ionomeric urea/urethane polymer comprising (a) repeating units derived from an aliphatic polyether polyol having a molecular weight of about 700 to about 1500, and (b)  
20 repeating units derived from a polyisocyanate,  
wherein the urea/urethane polymer contains less than about  
25 2 mole percent of urea units described by the formula –R – N(R<sup>2</sup>) – C(O) – N(R<sup>2</sup>) – R<sup>1</sup> –;  
wherein R is an aromatic C<sub>6</sub> – C<sub>20</sub> hydrocarbon radical, R<sup>1</sup> is an aliphatic C<sub>1</sub> – C<sub>20</sub> hydrocarbon radical, and R<sup>2</sup> is H or an amide group that is described by the formula - C(O) - N(R<sup>2</sup>) – R -.  
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11. A film according to Claim 10 which comprises repeating units derived from an ionic compound or a potentially ionic compound.
12. A film according to Claim 11 wherein the ionic  
35 compound or potentially ionic compound comprises a hydroxy-carboxylic acid of the general formula (HO)<sub>x</sub>R<sup>7</sup>(COOH)<sub>y</sub>, wherein R<sup>7</sup> represents a straight or branched hydrocarbon radical containing 1 to 12 carbon atoms, and x and y each independently represents values from 1 to 3.

13. A film according to Claim 11 wherein the ionic compound or potentially ionic compound comprises 2,2'-dimethanolpropionic acid.

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14. A film according to Claim 10 wherein the polyisocyanate is selected from the group consisting of toluene diisocyanate, methylene diphenyldiisocyanate and polymethylene polyphenylisocyanate.

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15. A film according to Claim 10 wherein the polyether polyol is described by the formula HO - [(CR<sup>5</sup>H)<sub>m</sub> - O -]<sub>n</sub> -H, wherein R<sup>5</sup> is hydrogen, a halogen or a C<sub>1</sub> to C<sub>4</sub> alkyl radical; m is 3 or 4; and n is in the range of about 8 to about 20.

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16. A film according to Claim 15 wherein R<sup>5</sup> is hydrogen.

17. A film according to Claim 10 wherein the polyether polyol has a molecular weight in the range of about 900 to about 1150.

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18. A film according to Claim 10 wherein the urea/urethane polymer contains less than about 1 mole percent of the described urea units.

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19. A film according to Claim 10 that is prepared from an aqueous dispersion of the urea/urethane polymer of Claim 10 and a surfactant.

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20. A film prepared from an ionomeric urea/urethane polymer comprising (a) repeating units derived from an aliphatic polyester polyol, and (b) repeating units derived from a polyisocyanate, wherein the urea/urethane polymer contains less than about 2 mole percent of urea units described by the formula -R - N(R<sup>2</sup>) - C(O) - N(R<sup>2</sup>) - R<sup>1</sup>;

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wherein R is a C<sub>6</sub> - C<sub>20</sub> aromatic hydrocarbon radical, R<sup>1</sup> is a C<sub>1</sub> - C<sub>20</sub> aliphatic hydrocarbon radical, and R<sup>2</sup> is H or an amide group that is described by the formula C(O) - N(R<sup>2</sup>) - R -.

21. A film according to Claim 20 which comprises repeating units derived from an ionic compound or a potentially ionic compound.
22. A film according to Claim 21 wherein the ionic
- 5 compound or potentially ionic compound comprises a hydroxy-carboxylic acid of the general formula  $(HO)_xR^7(COOH)_y$ , wherein  $R^7$  represents a straight or branched hydrocarbon radical containing 1 to 12 carbon atoms, and  $x$  and  $y$  each independently represents values from 1 to 3.
- 10 23. A film according to Claim 21 wherein the ionic compound or potentially ionic compound comprises 2,2'-dimethanolpropionic acid.
24. A film according to Claim 20 wherein the polyisocyanate
- 15 is selected from the group consisting of toluene diisocyanate, methylene diphenyldiisocyanate and polymethylene polyphenylisocyanate.
25. A film according to Claim 20 wherein the polyester polyol is a dihydroxy-terminated polymer selected from the group
- 20 consisting of an ethylene adipate, a butylene adipate, an ethylene/butylene adipate, and mixtures thereof.
26. A film according to Claim 20 wherein the urea/urethane polymer contains less than about 1 mole percent of the described urea
- 25 units.
27. A film according to Claim 20 that is prepared from an aqueous dispersion of the urea/urethane polymer of Claim 20 and a surfactant.
- 30 28. A film according to Claims 1, 10 and 20 that is fabricated in the form of a glove.
29. A glove according to Claim 28 wherein the glove is not
- 35 perforated or broken at the point of contact between the thumb and forefinger after the thumb and forefinger have dipped in isopropyl alcohol and rubbed together for a time of about 30 to about 60 seconds.